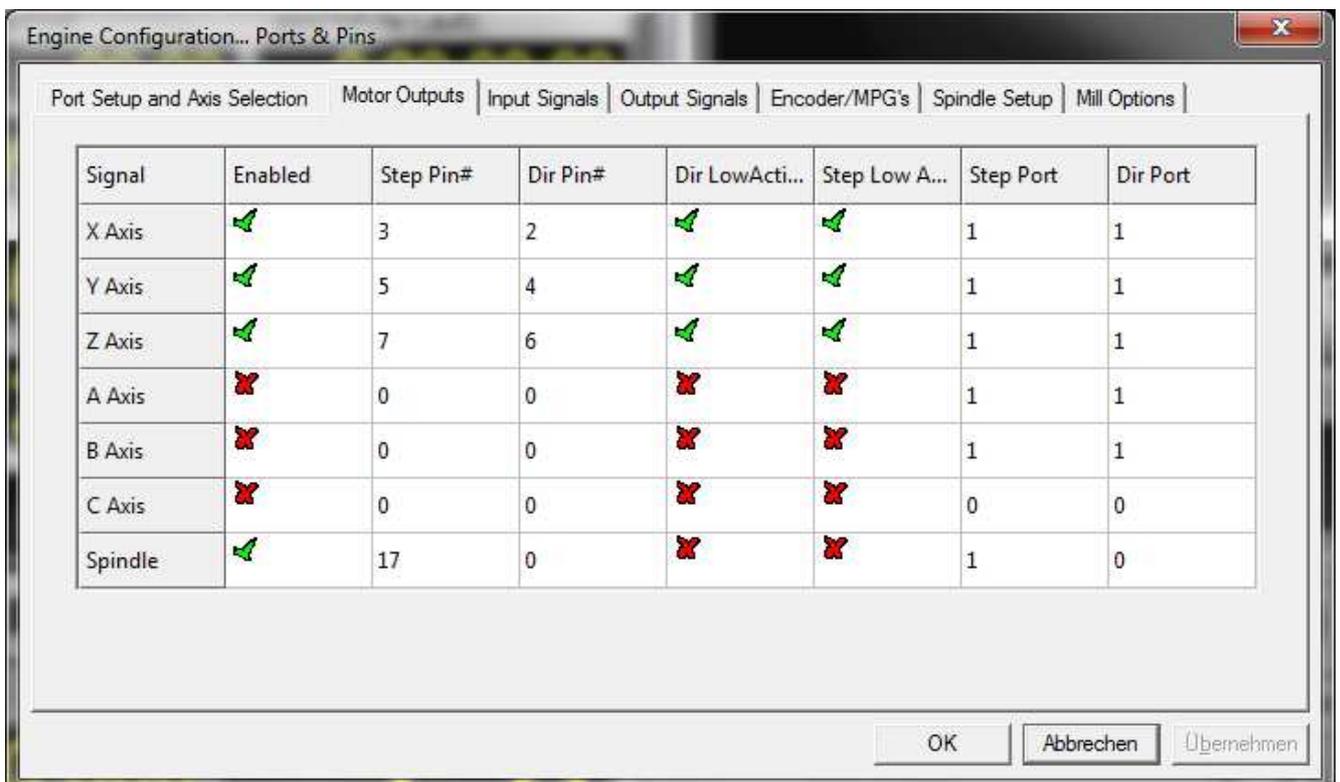
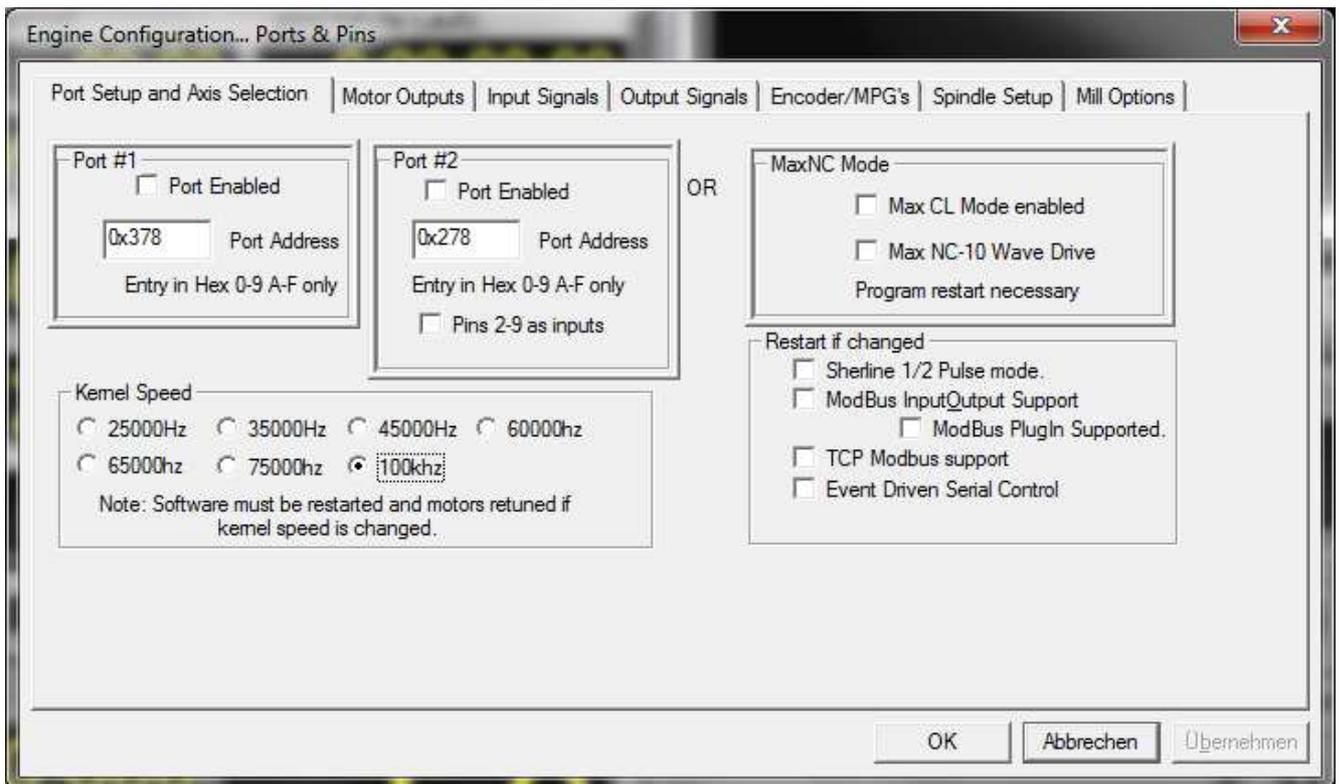
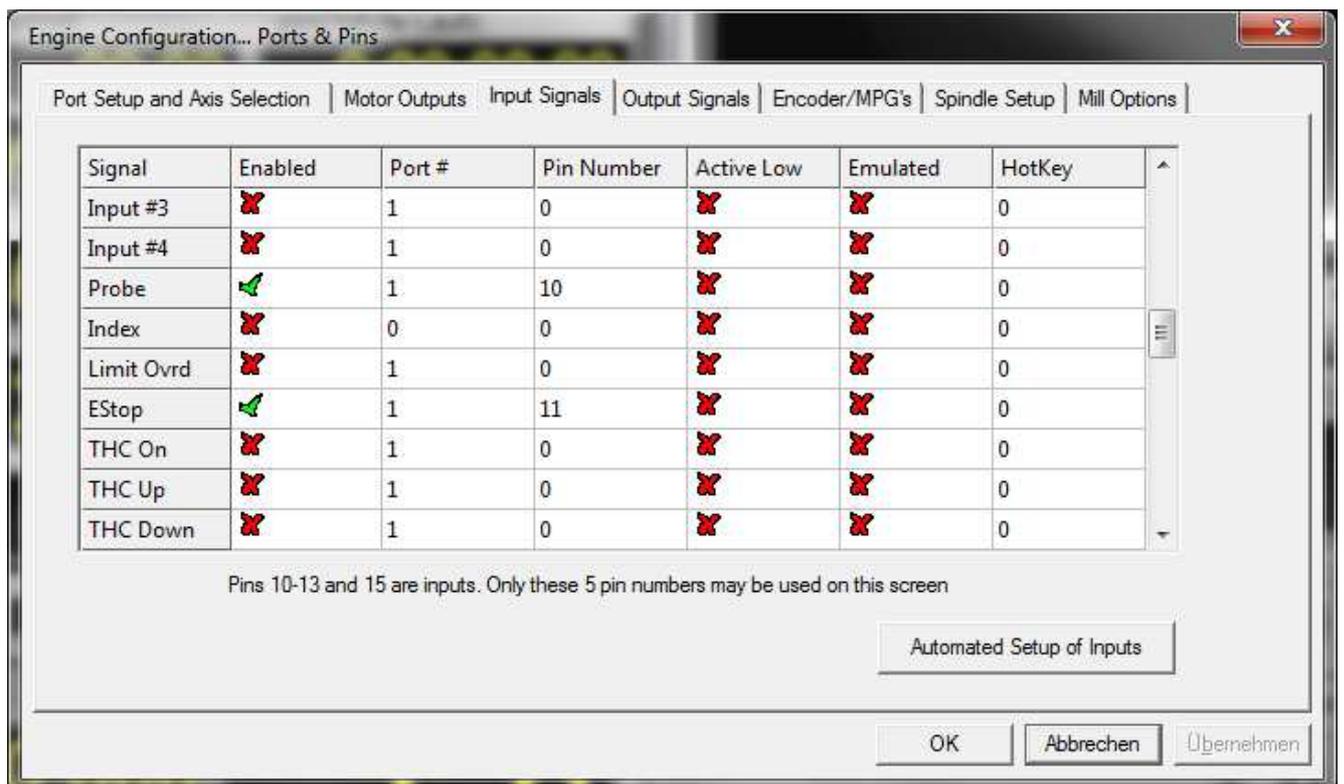
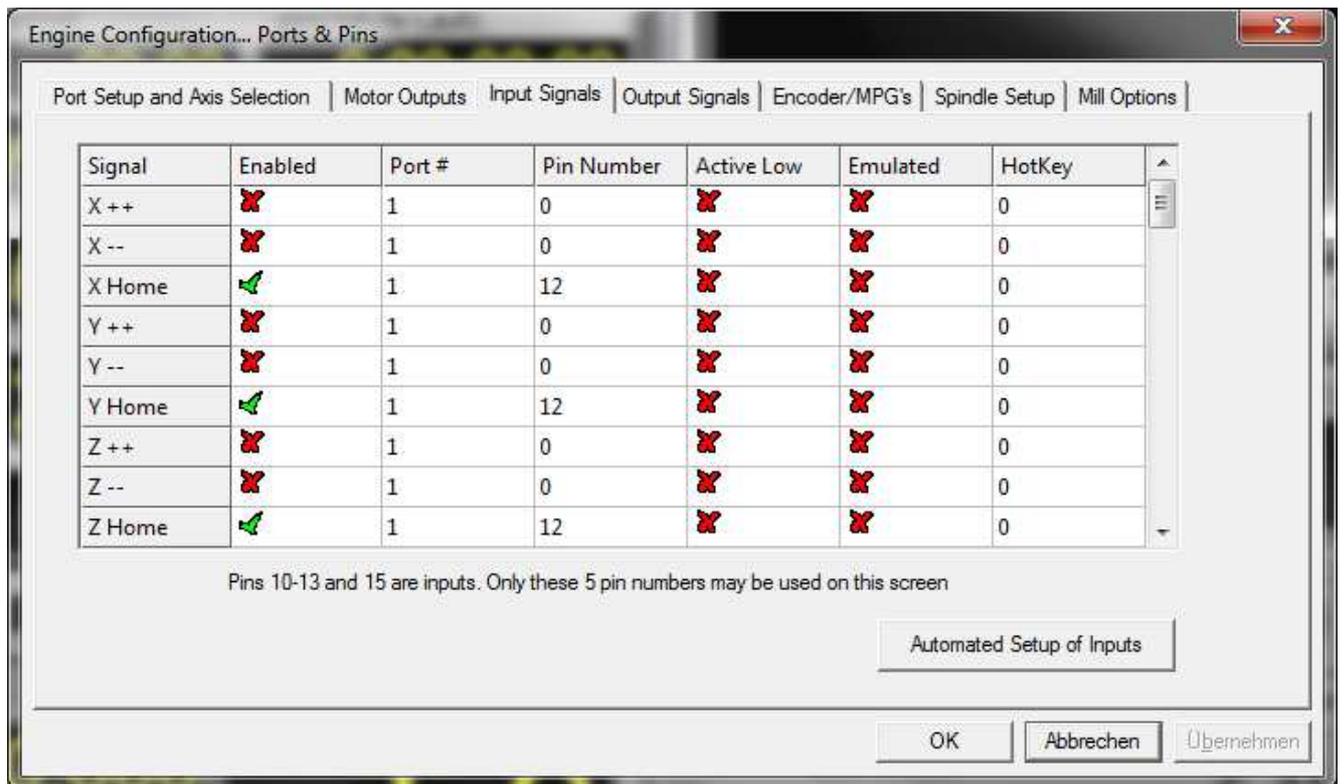
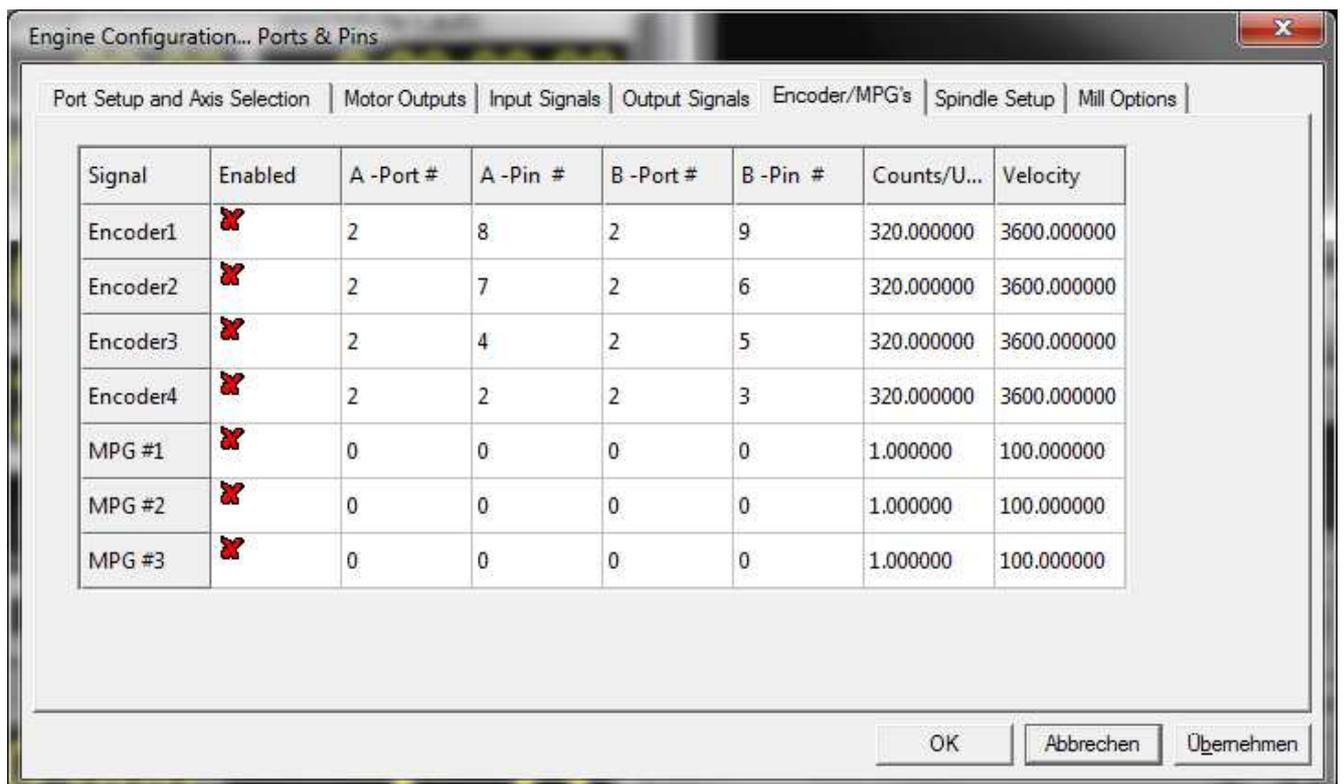
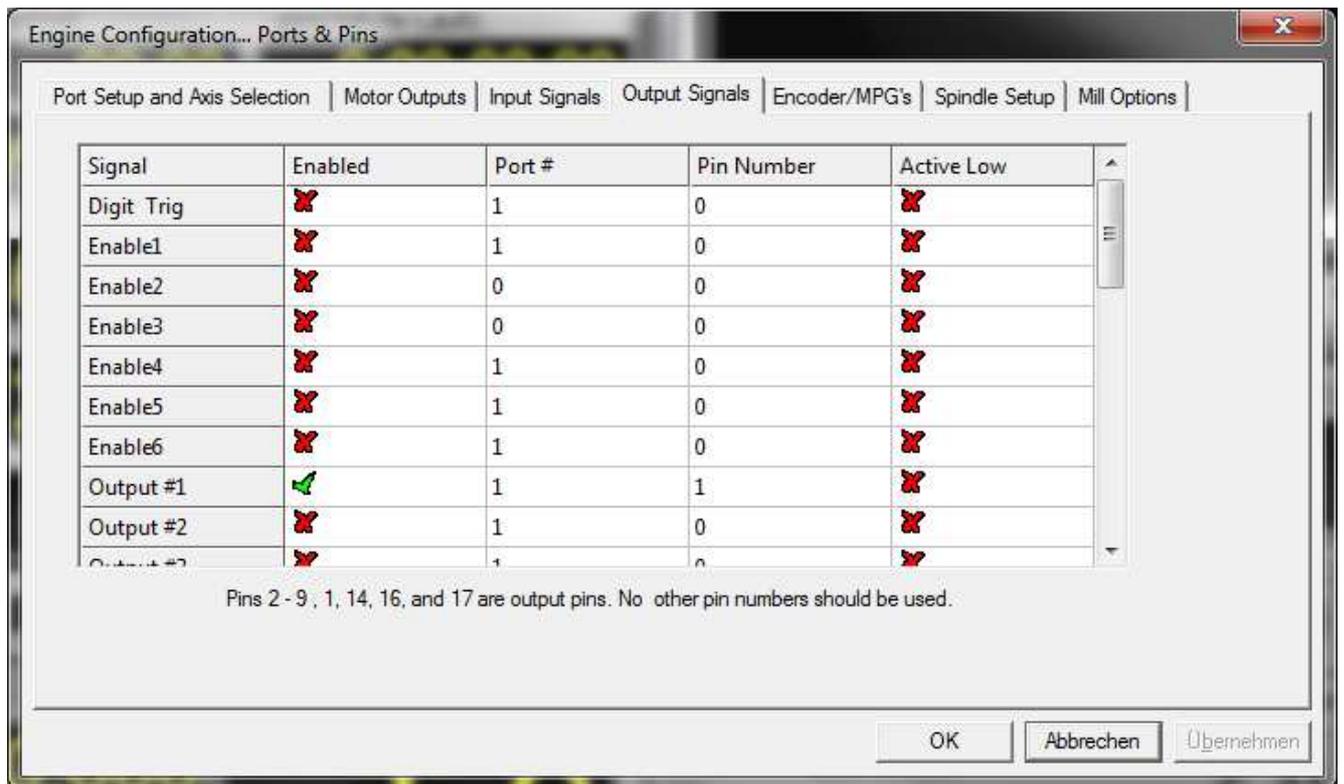
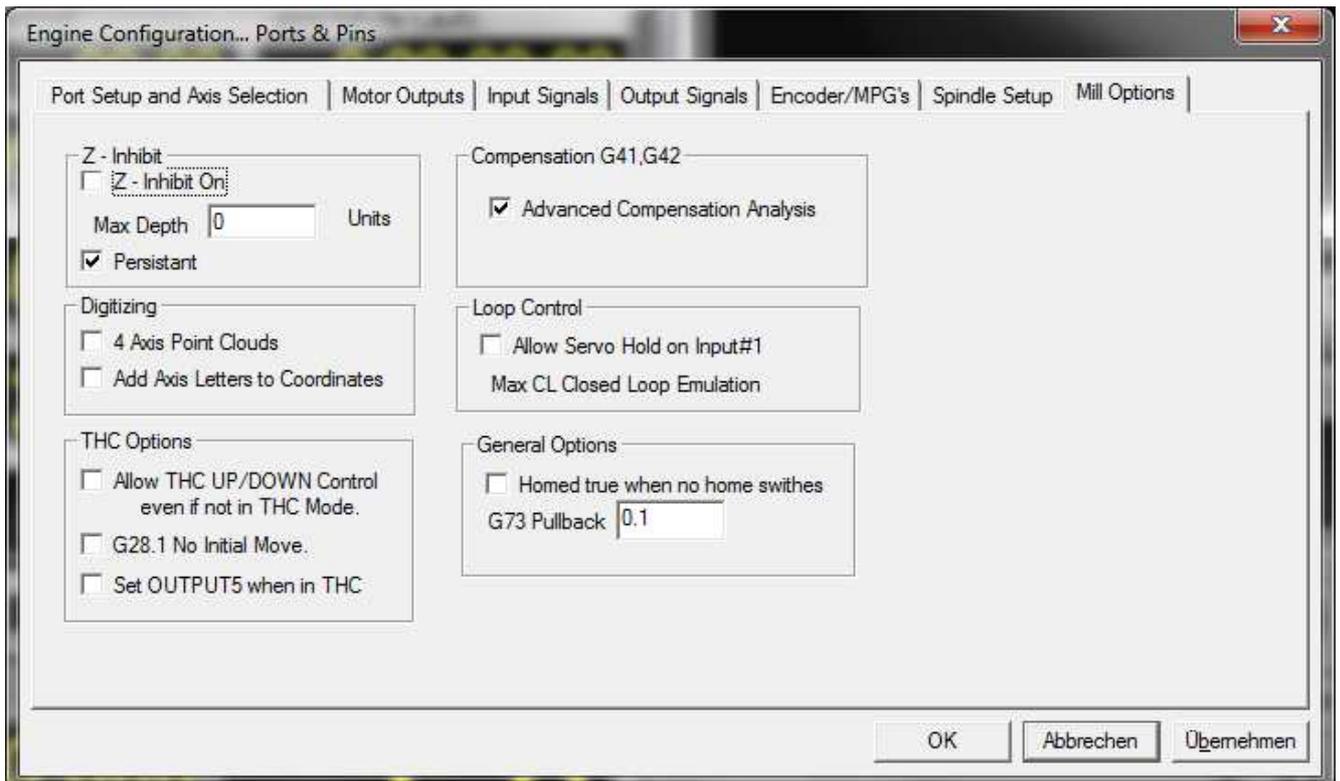
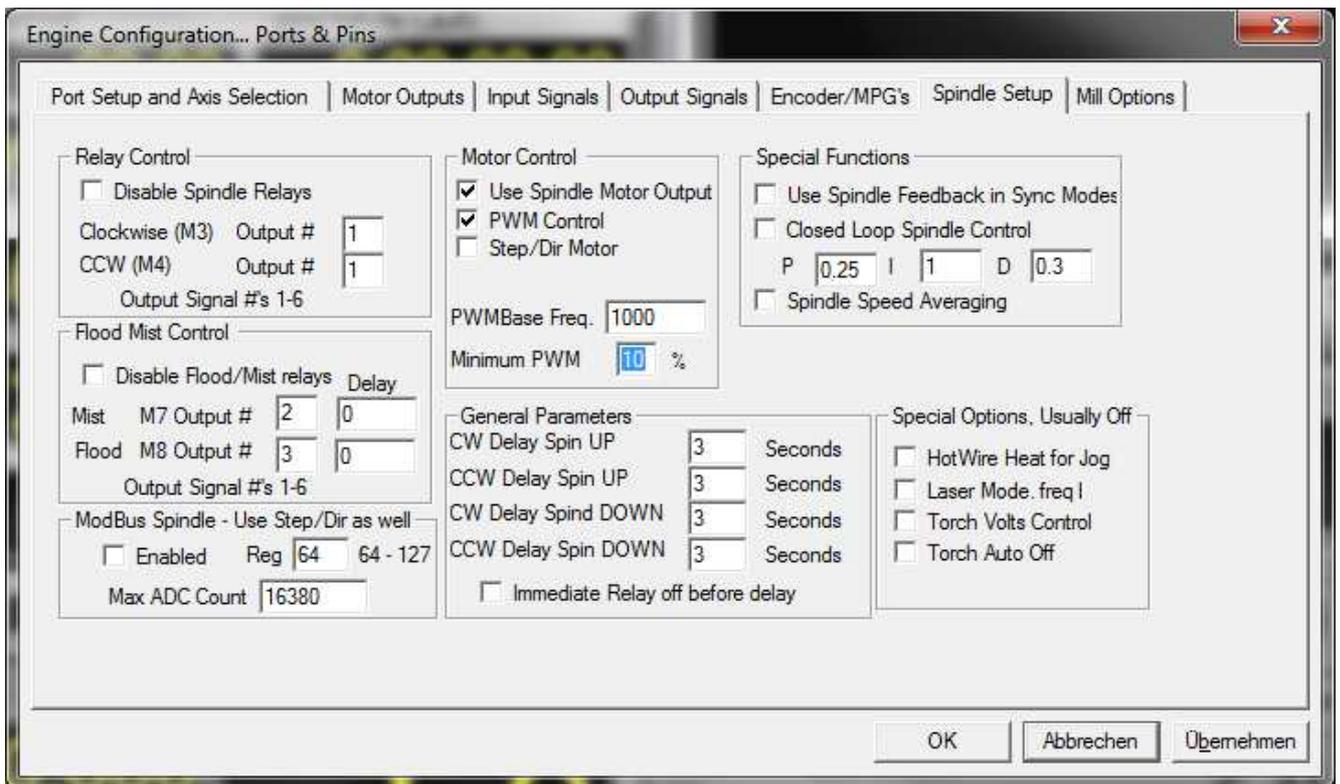


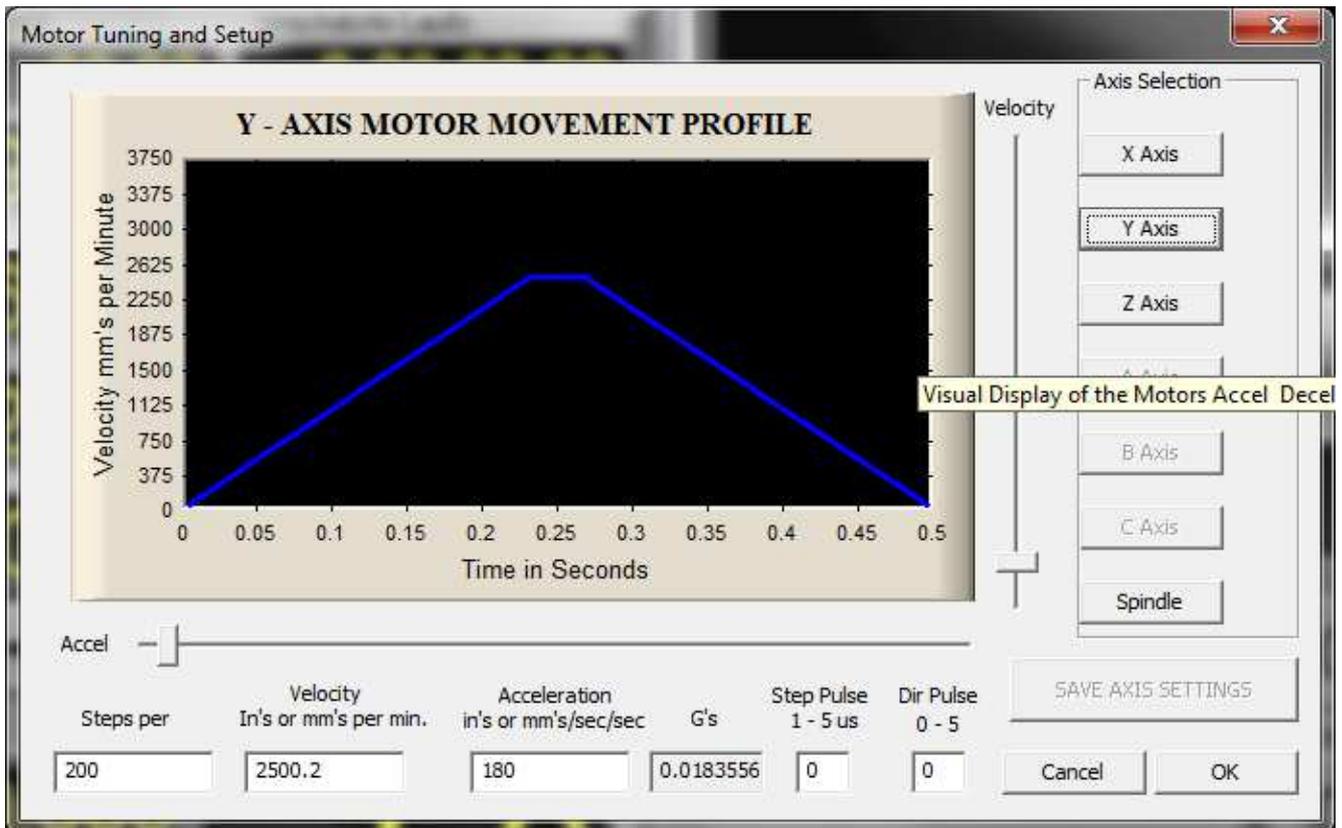
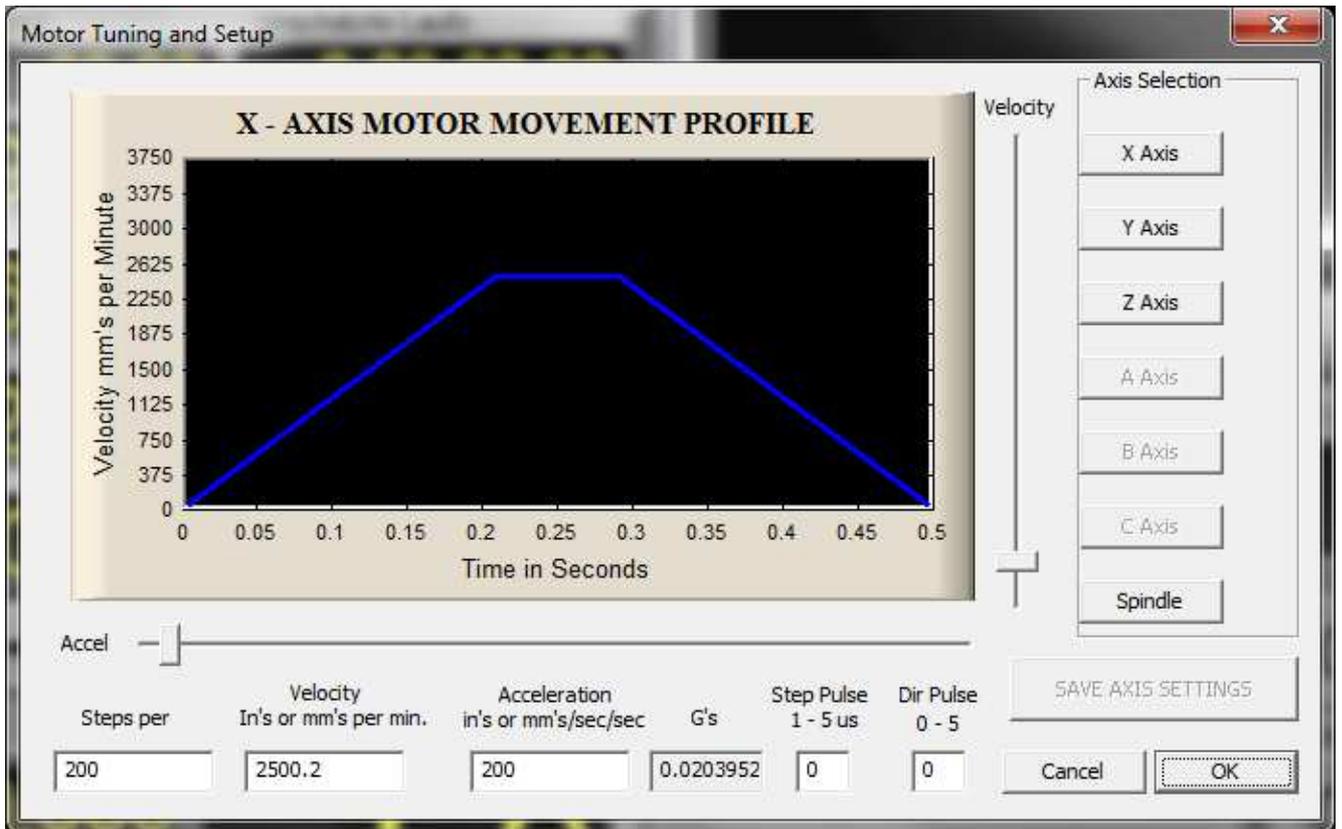
Meine Einstellungen für die Stepcraft 420 V1 mit Motioncontroller UC-100 (<http://cncdrive.com/>) und Mach3 unter Windows 7, 32Bit.

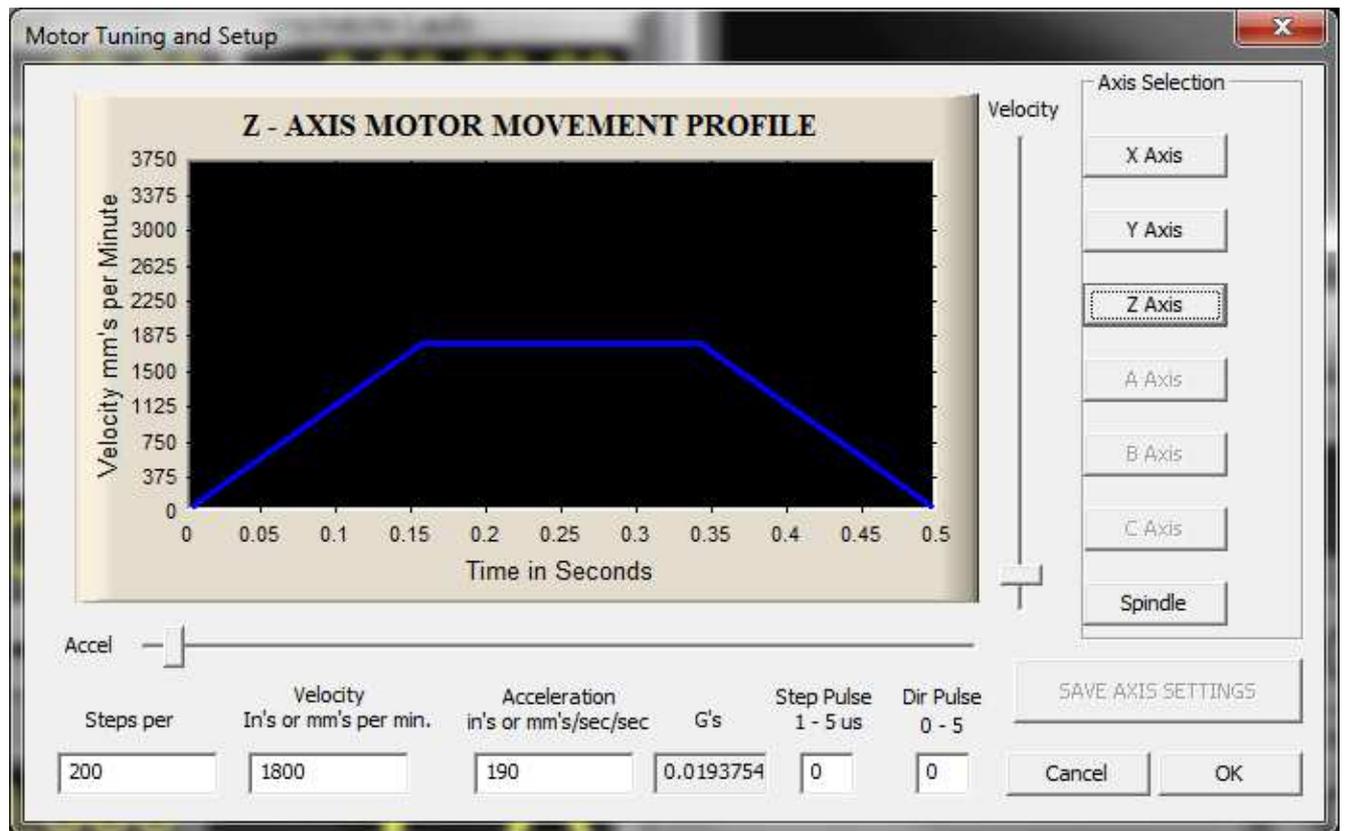












General Logic Configuration

G20,G21 Control

- Lock DR0's to setup units

Tool Change

- Ignore Tool Change
- Stop Spindle, Wait for Cycle Start
- Auto Tool Changer

Angular Properties

- Unchecked for Linear
- A-Axis is Angular
- B-Axis is Angular
- C-Axis is Angular

Pgm End or M30 or Rewind

- Turn off all outputs
- E-Stop the system
- Perform G92.1
- Remove Tool Offset
- Radius Comp Off
- Turn Off Spindle

M01 Control

- Stop on M1 Command

Serial Output

ComPort # [1] BaudRate [9600]

- 8-Bit 1 Stop
- 7 Bit 2-Stop

Program Safety

- Program Safety Lockout

Editor

GCode Editor [Browse]

[C:\Windows\notepad.exe]

Startup Modals

- Use Init String on ALL "Resets"

Initialization String [G80 F1200]

Motion Mode

- Constant Velocity
- Exact Stop

Distance Mode

- Absolute
- Inc

IJ Mode

- Absolute
- Inc

Active Plane of Movement

- X-Y
- Y-Z
- X-Z

Jog Increments in Cycle Mode

Position	Increment
Position 1	1
	0.1
	0.005
	0.001
Use 999 to indicate a	1
Continuous Jog selection,	5
	0.005
	0.003
Position 10	90
	180

Shuttle Wheel Setting

Shuttle Accel. [0.01] Seconds

Inputs Signal Debouncing/Noise rejection

Debounce Interval [10] x 40us

Index Debounce [10]

General Configuration

- Z is 2.5D on Output #6
- Home Sw. Safety
- LookAhead [200] Lines
- Ignore M calls while loading
- M9- Execute after Block
- UDP Pendant Control
- Run Macro Pump
- ChargePump On in EStop
- Persistent Jog Mode.
- FeedOverride Persist
- No System Menu in Mach3
- Use Key Clicks
- Home Slave with Master Axis
- Include TLD in Z from G31
- Lock Rapid FRD to Feed FRD

Rotational

- Rot 360 rollover
- Ang Short Rot on G0
- Rotational Soft Limits

Screen Control

- Hi-Res Screens
- Boxed DR0's and Graphics
- Auto Screen Enlarge
- Flash Errors and comments.

Disable Gauge/Concavity Checks

- G04 Dwell in ms
- Use WatchDogs
- Debug This Run
- Enhanced Pulsing
- Allow Wave Files
- Allow Speech
- Set Charge Pump to 5Khz - Laser Stndby
- Use OUTPUT20 as Dwell Trigger
- No FRD on Queue

CV Control

- Plasma Mode
- CV Dist Tolerance [10] Units..
- G100 Adaptive NurbsCV
- Stop CV on angles > [90] Degrees

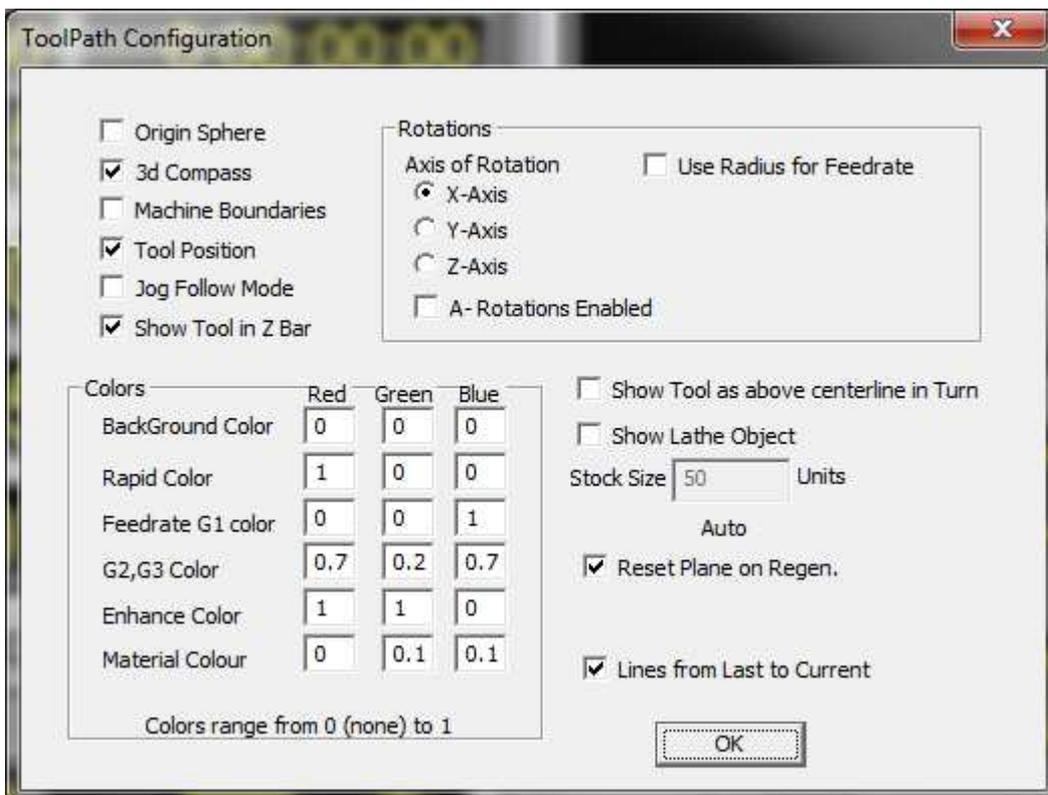
Axis DRD Properties

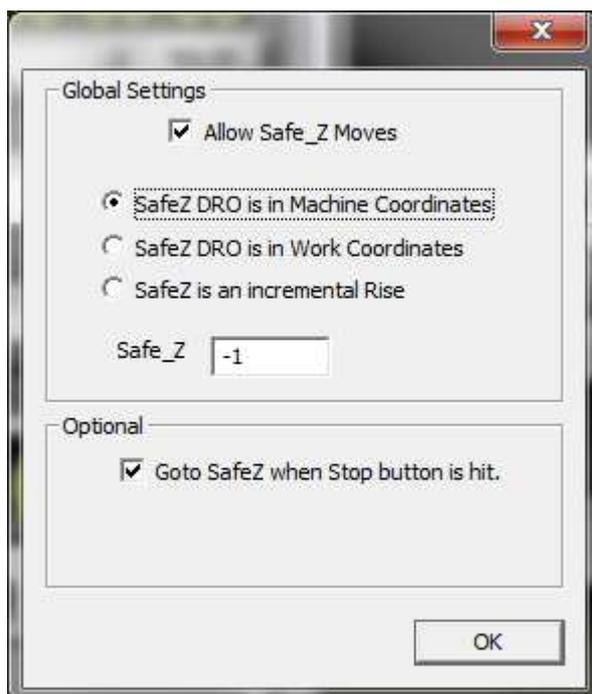
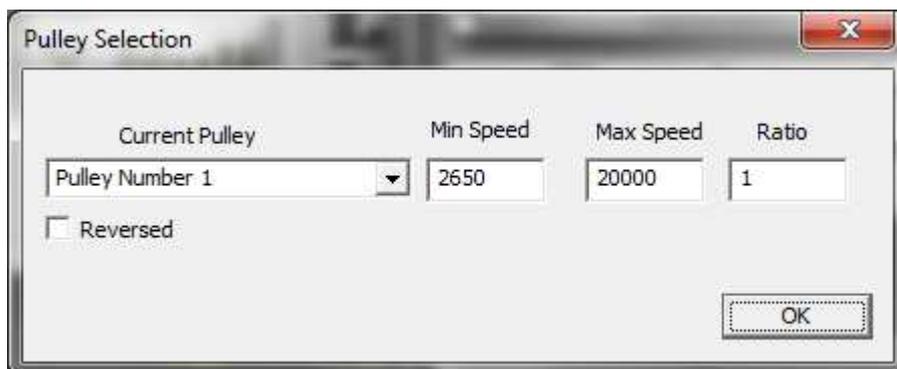
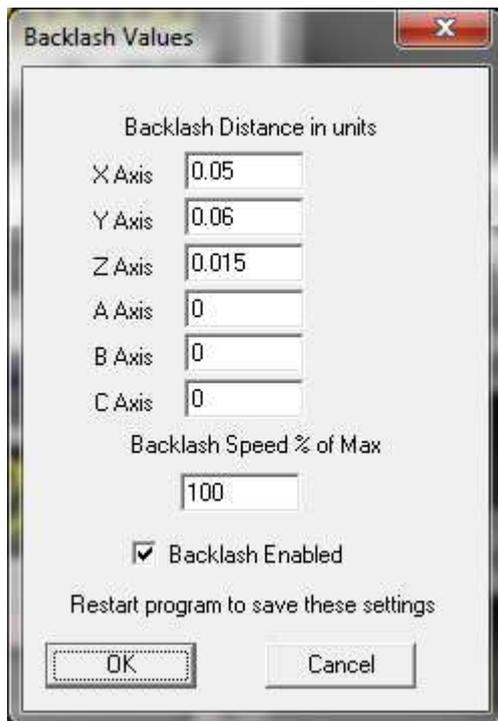
- Tool Selections Persistent.
- Optional Offset Save
- Persistent Offsets
- Persistent DR0's
- Copy G54 from G59.253 on startup.

Turn Manual Spindle Incr. [1]

Spindle OV increment [1]

OK





Motor Home/SoftLimits

Entries are in setup units.

Axis	Reversed	Soft Max	Soft Min	Slow Zone	Home Off.	Home N...	Auto Zero	Speed %
X		302.00	0.00	2.00	0.0000			9
Y		412.00	0.00	2.00	416.0000			9
Z		0.00	-82.00	1.00	0.0000			15
A		0.00	0.00	200.00	0.0000			20
B		1000.00	0.00	20.00	0.0000			20
C		100.00	-100.00	1.00	0.0000			20

G28 home location coordinates

X	<input type="text" value="0"/>	A	<input type="text" value="0"/>
Y	<input type="text" value="0"/>	B	<input type="text" value="0"/>
Z	<input type="text" value="0"/>	C	<input type="text" value="0"/>

OK